

5046116



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DAS
13
9-89

FEB 1 2018

D2622-120C

Job Sheet 169461



FEB 13 2018

Part No: D2622-120C

Job Qty: 66 ea

Part Name: Step Extrusion



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/12/17

Job Tracking No:

Due Date: 12/21/17

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	66 pcs	12/21/17	12/21/17	0.00	0.00	Purchasing		DAS 13 9-89 FEB 27 2018
110	Packaging	66 pcs	12/21/17	12/21/17	0.00	0.00	Packaging2		DAS 13 9-89 FEB 27 2018
120	QC	66 pcs	12/21/17	12/21/17	0.00	0.00	QC18		DAS 13 9-89 FEB 27 2018
130	Packaging	66 pcs	12/21/17	12/21/17	0.00	0.00	Packaging3-1		DAS 13 9-89 FEB 27 2018
140	QC21-SA	66 Ea	12/21/17	12/21/17	0.00	0.00	QC21		DAS 13 9-89 FEB 28 2018

Part Op 100 - Issue P/O: 38627 a) Extrude as per Dwg D2622 Rev. C f) Order at 120" longg) Bon L Canada Inc.
 Descriptions: 110 - Ensure material certification is attached
 120 - Check Pull test per Dwg D2622 for compliance page attached Check hardness with Webster tester
 130 - LOCATION : HALL

DEC 11 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D2622-120CP	66	0	0	0

Part Specifications

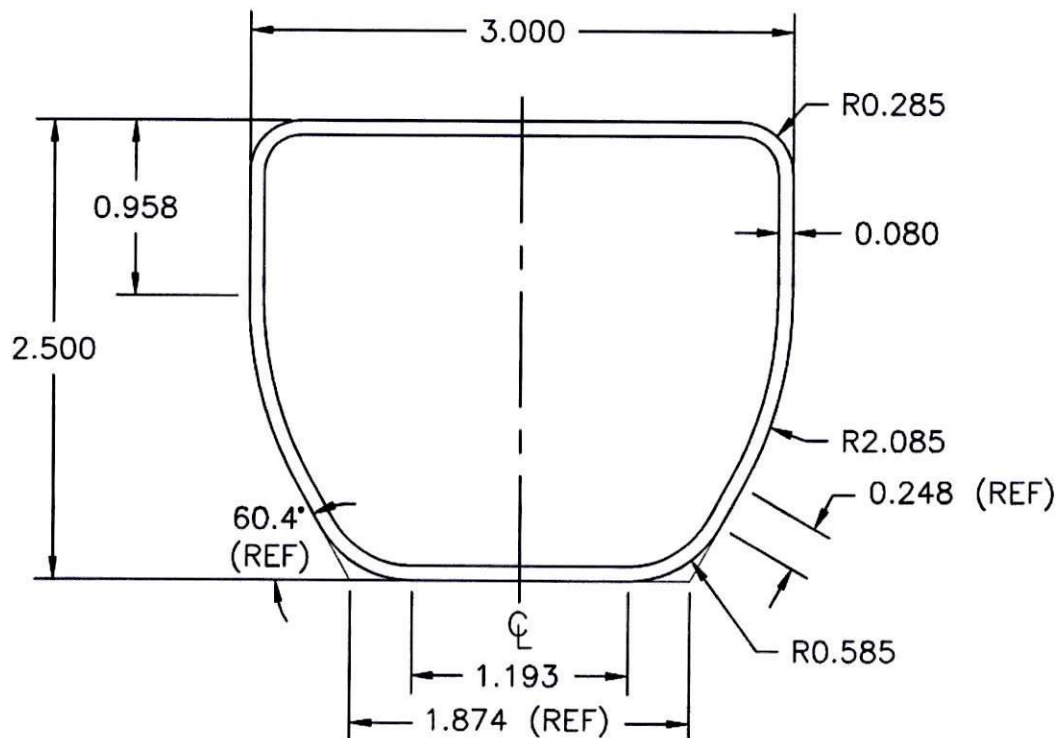
Specifications could not be found.

Plex 12/12/17 11:03 AM dart.lavoie.chantal



DESIGN KE	DRAWN BY GP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2622	REV. C SHEET 1 OF 1
DATE 02.09.11		TITLE STEP EXTRUSION	SCALE 1:1
A	96.11.29	NEW ISSUE	
B	97.12.12	CHANGE MATERIAL, ADD TOL. QSI	
C	02.09.11	0.080 WAS 0.085; ADD PART & DIE No.	
CI	GP 02.10.04	ADD 'REV. A' TO DIE NUMBER.	

RELEASED
02.09.11 H



D2622-XXX STEP EXTRUSION

1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)

2) MATERIAL 6061-T6 (QQ-A-200/8)

3) MANUFACTURED USING BON-L DIE # 897123 REV. A

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi

MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi

MINIMUM ELONGATION = 8%

5) PART IS SYMMETRIC ABOUT CENTERLINE

6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-120C
 DATE: FEB 27 2018

PO / BATCH NO.: 038627/5046116

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 266
 QUANTITY INSPECTED: 266
 QUANTITY REJECTED: 0

THICKNESS ORDERED: W.O.080
 THICKNESS RECEIVED: W.O.080
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL PER M-DRAWING	Y	N	<u>Astm B22.1</u>
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT REF # TO LINK CERT	Y	N	<u>Lot # 38627</u>
CORRECT MATERIAL IDENTIFICATION	Y	N	
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>DAS</u> <u>11</u> DATE: <u>9-89</u> <u>FEB 27 2018</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
07/30/2017	5467068	131101	1
Cust PO	B/L No	Lot	Date
PO038627	036059	895177	02/26/18

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP
Gross Weight	2,480 LBS		
Net Qty	2,374 LBS 266 PCS 6 PKGS		
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield			
MPA / KSI	MPA / KSI	% Elongation	Conductivity	HRE
303.5 / 44.0	272.4 / 39.5	10.1	N/A	93

Chemical Analysis:

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	V	Zr
0.67	0.25	0.23	0.04	0.90	0.05	0.24	0.01	0.01	0.01

*This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

ACCT# 46024

SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

PACKING LIST DATE / DATE DU
02-26-18

PACKING LIST NUMBER / N° DE
036059

SALES ORDER NUMBER / N° DE COM
131101

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

LOCATION	TRAILER NUMBER / REMORQUE Nombre	SALESMAN / VENDEUR	CREDIT REP / REP DU CRÉDIT	SALES REP / REP. DES VENTES
PIC	160	042		R. BLAIS
JOB / FICHIER	CARRIER / TRANSPORTEUR	FIELD SALES REP / REP REGIONAL DES VENTES	CUST SERVICE REP / REP. SERVICE CLIENTELE	
	MCGILLION	G.ATTENBOROU	S1S	

CUSTOMER ID / ID DU CLIENT

ORDER DATE / DE LA
COM

CUSTOMER PO NUMBER / CLIENT PO Nombre

PO038627

46024

02/13/18

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

036059

CARRIER / TRANSPORTEUR
MCGILLION

FIELD SALES REP / REP
REGIONAL DES VENTES

CUST SERVICE REP / REP.
SERVICE CLIENTELE

G.ATTENBOROU

S1S

ITEM NO. / NUMÉRO	ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITÉ	PREVIOUS SHIPPED QUANTITY / PRÉCÉDENT Quantité livrée	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	FINISH DESCRIPTION / DESCRIPTION DE FINITION	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITÉ	QUANTITY DUE / Quantité en raison
001	2,198	LB		DAA-897123-2	6061 T6		6	2,480	2,374	LB	
	997	KG		D2622-120CP	120.0000 IN			1,125	1,077	KG	
Y	241	PC			Cut(+): 0.1180 Cut(-): 0.0000	Min: -10 % Max: 10 %			266	PC	
						895177 / 413096	1	452	434		49 PC
						895177 / 413097	1	452	434		49 PC
						895177 / 413098	1	373	355		39 PC
						895177 / 413099	1	300	282		31 PC
						895177 / 413100	1	452	434		49 PC
						895177 / 413102	1	452	434		49 PC

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards set of 1993 as amended. Orders accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1 of 4

		Continued	
TOTALS			

DATE OF DELIVERY

DRIVER



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S046116



Part: D2622 - 120C

Job No: 169461

Serial No/Batch: S046116

Revision:

Inspector:

Date: 02/27/18